

Work Order ID 80016

80016

Page 1

Wednesday, February 08, 2012 3:54:15 PM

Item ID: D4006-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tank Top Support Assembly

Stop *NS2*

Start Date: 2/9/2012 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: *mk* Date: 12-02-08 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4006	A/B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

Small Fab

Memo

Small Fab Assemble as per dwg D4006

110	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

Quality Control

120	Grey "ALISA G1 Grey" Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

120

Powdercoat

Memo

Powder Coating

Start Time: 12:15
Oven Temperature: 320 °F
Finish Time: 12:45

M118533

12/03/08 (Signature)

(Signature)

4x6 m-f 12/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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4

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

502103/09

(4)

140

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1- Apply glue and install Foam as per dwg
Batch: 1120225
2- Install anchor nuts as per dwg

3M 1300 countact cement

Basket glue

(4)

FF 12-03-09

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

502103/09

(4)

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Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 141A

0.00

160

Packaging

Memo

0.00

Packaging

12/3/09 (4)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/03/09

1239

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Picklist Print

Wednesday, February 08, 2012 3:54:14 P

Page 1

Work Order ID: 80016

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 2/9/2012

Required Date: 2/28/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD
562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM
IPP Rev:B 10.05.03 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 Angle		Manufactured	No			100	Each	4.0000	1	4		2/12/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4				4			
				70187		4							
D4006-3 Channel		Manufactured	No			100	Each	2.0000	2	8		2/12/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST107		2						B 73556 (7x)	
				72752		2						B 80627 (1x)	
D4006-5 Foam		Manufactured	No			140	Each	0.0000	1	4		2/12/08	
MS20426AD3-4 RIVET		Purchased	No			140	Each	4,078.0000	4	16		FF 12-03-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		4078							
				104374		1024				16			
				110398		3054							
MS20470AD4-5 Rivet, Universal Head		Purchased	No			100	Each	3,059.0000	8	32		2/12/08	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		3059				32			
				118405		1406							
				120142		1653							

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Picklist Print

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Page 2

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Parent Item: D4006-041

Start Date: 2/9/2012

Required Date: 2/28/2012

Parent Item Name: Tank Top Support Assembly

Start Qty: 4.00

Required Qty: 4.00

MS21059L4

Purchased

No

140

Each

53.0000

2

8

Nutplate

8 12/03/10

Location

Loc Qty

Loc Code

ST301

53

117887

3

119623

50

8

W/O:		WORK ORDER CHANGES					
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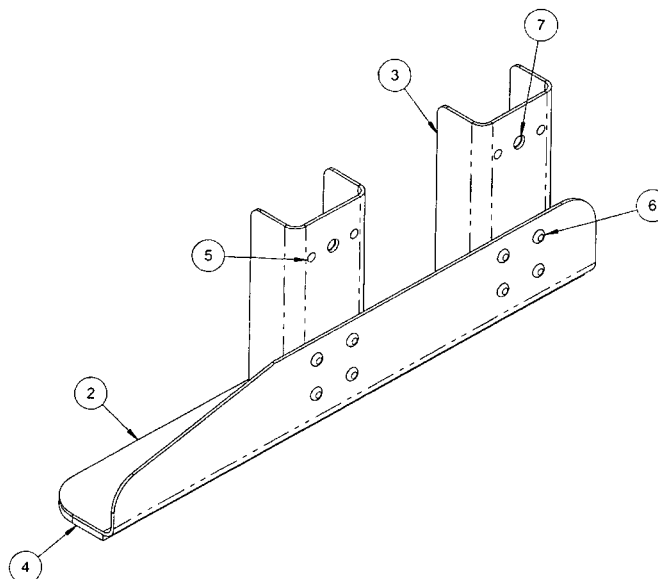
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3(-4)	RIVET	
6	8	MS20470AD4(-5)	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.48 lbs



B	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY", ZN A7-1.	DC	12.02.28
A	NEW ISSUE	BY	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4006	SHEET 1 OF 6
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	UPPER RESTRAINT	NTS
DATE	12.02.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2012-03-02
WP

#80016

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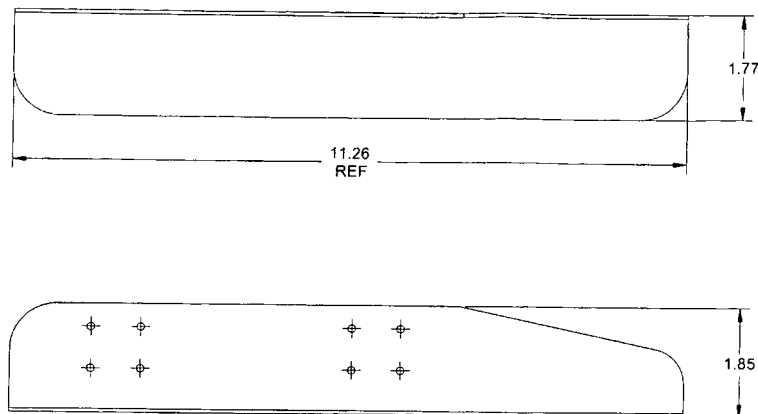
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4006-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01



D4006-1 ANGLE

R0.19

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	EE	D4006	SHEET 2 OF 6
APPROVED	MA	TITLE	SCALE
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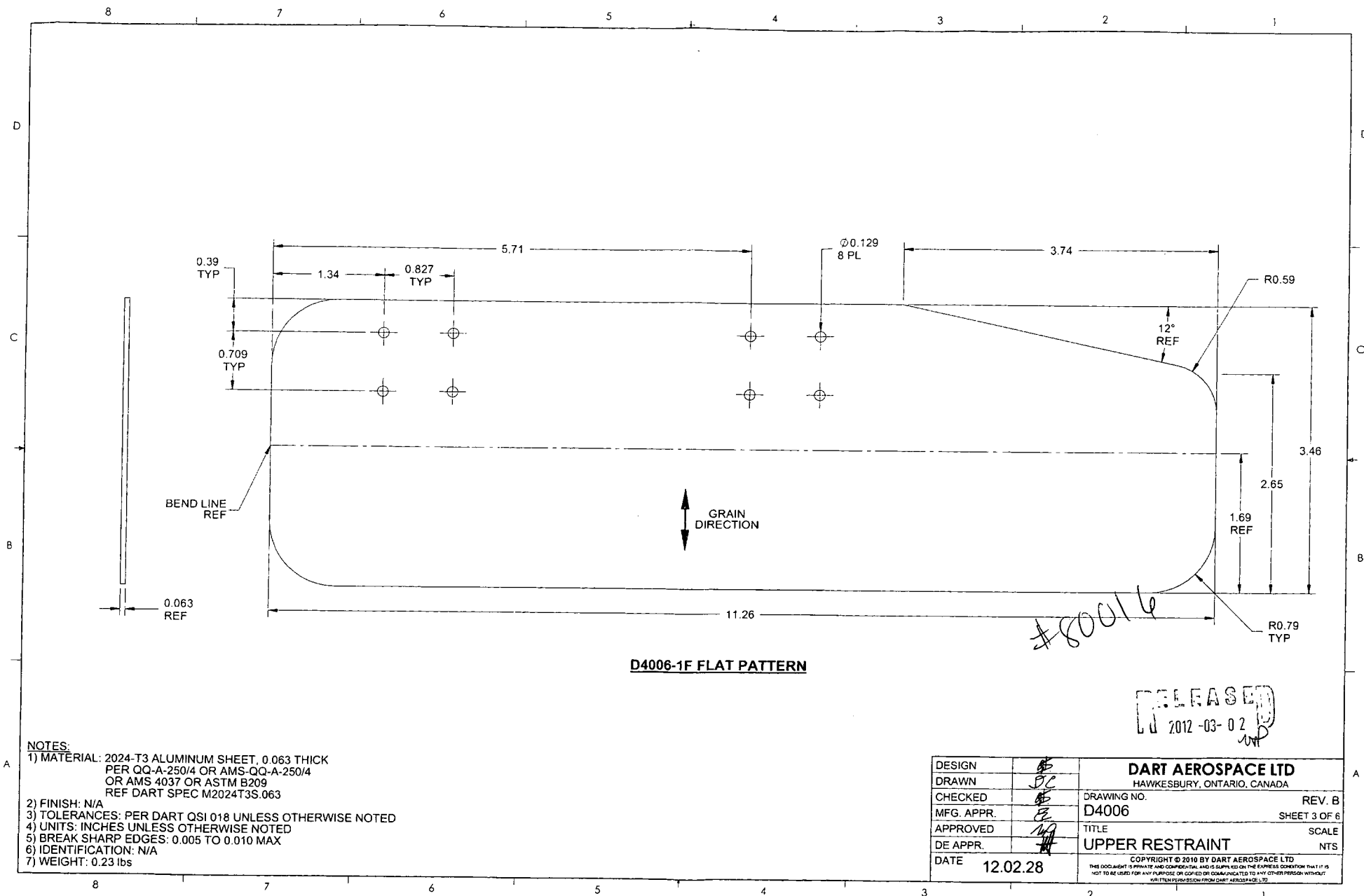
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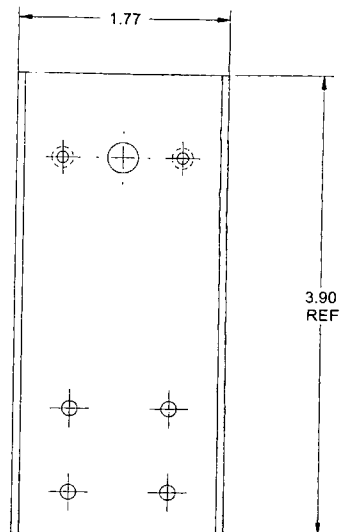
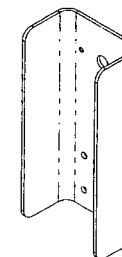
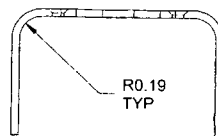
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4006-3

JOHN CAMERON AVIATION
PART NUMBER

REF JCA-M47-2-01



80016

D4006-3 CHANNEL

RELEASED
2012-03-03

NOTES:

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 LBS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4006	SHEET 4 OF 6
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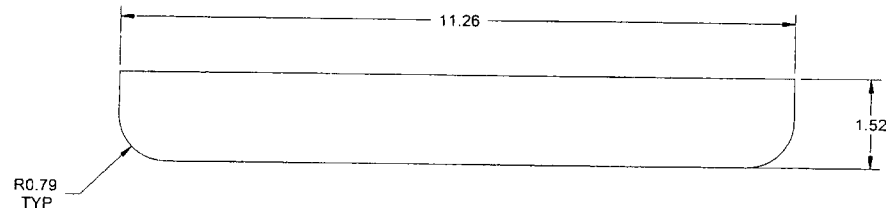
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



D4006-5 FOAM

#80014

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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